0 <u>Ae</u> 13.08.13

0.00

0.00

QC2- Inspect parts off machine FAI/FAIB

Memo

110

QC

110

Quality Control

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Crosstube Skid-tube Water Jet Engineering Rework Machining Small Fab Prod. Eng. Coor. Quality Part No. Scrap Rec/Store/Packaging Use-as-is Thermoforming Finishing Other Composite Work Order Update Large Fab NCR No. Supplier Description of work order update Action Sign & Root Initial **Chief Eng** Date Verification QC Inspector Cause Date Step Qty or Non-conformance Description Doc/Data Equip/Tooling Operator Material Setup Other

Landing Gear General Pressure/Forced Bend Grain Ovalized Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Broken/Damaged Weld Inspection Incomplete Part Incorrect Cracks Crushed/Crimped Wrong Stock Pulled Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled · Positioned Wrong Cut Too Short Power Loss/Surge Other Inspection Strip in Tube Misread **Drill Holes** Offset Ripples in Bend **Out of Calibration** Torque Waves in Extrusion Drawing **Turning Sequence** Finish Out of Sequence

Outside Dimensions

FAULT CATEGORY

Wave/Twist in Tube

Folio

Process
Supplier
Training
Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 101658

Page 2 May-13-13 1:11:00 PM Item ID: D3207-5 Accept *N900040100* Setup Start **Revision ID:** Item Name: Bracket *10* 5/15/13 Start Qty: 10.00 Start Date: **Cust Item ID:** Req'd Qty: 10.00 Required Date: 5/31/13 *10* Customer: Reference: Run Date: Tooling: Date: Approvals: Process Plan: Stop QC: Date: SPC (Y/N): Date: Tool ID Sequence ID/ Reject Reject Operation Set Up/ Tool # Plan Accept Insp. Work Center ID Qty Number Stamp Description Code Qty Run Hours 120 OC8- Inspect parts - second check 0.00 *120* OC Memo Quality Control 130 Form as per dwg 0.00 NC BRAKE *130* 0.00 Brake NC Memo Brake NC

140

140 QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

NCR: Y	es / N)			WORK ORDER NON-O	100	NFORI	MANCE / UPI	DATE				
										QA Closed:	Da	te:	
Work Orde	er:				DISPOSITION	1			_	EPARTMENT,	,		
Part N	lo				Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR N	lo	<u> </u>			Work Order Update]		Large Fab	Composite		Supplier	$\boldsymbol{\vdash}$	
Root				Descri	iption of work order update	1	nitial	Act	tion	Sign &			<u>-</u>
Cause	Dat	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verificatio	n	QC Inspector
Doc/Data	_												
Equip/Tooling	_											- 1	
Operator]									
Material							٠.,						
Setup						* ;	**************************************	1					
Other			i				-						
Process	_					}							
Supplier													
Training			İ										
Unapproved			<u> </u>	<u> </u>				<u></u>		•			
					F.	AUL	T CATE	GORY					
Landir	ng Gear			_	General				_	7		_	
	Bendi	-		<u> </u>	Bend	\vdash	Grain		<u> </u>	Ovalized		—	ressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route	\vdash	Hardwa		L	Over/Under	tolerance		emperature/Cure
İ	Cracks			<u> </u>	Broken/Damaged	-	1	ion Incomplete	⊢	Part incorred			/eld
		d/Crimped			Burrs			tions Incomplete/U	Jnclear	Part Lost/Mi	ssing	∐′^	rong Stock Pulled
	Cuffs			L	Contamination	_	Mainte		L	Part Moved			•
	Heat 1	reat			Countersink		Mislabe	eled	L	Positioned V	-	_	
1	Inspec	tion Strip ir	1 Tube	<u></u>	Cut Too Short		Misread	.	L	Power Loss/	Surge	<u></u>	ther
	Ripple	s in Bend			Drill Holes		Offset						
	Torqu	e Waves in	Extrusio	n 🗍	Drawing		Out of	Calibration					

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

D3207-5

May-13-13 1:11:00 PM

Item ID:

101658

Accept

0.00

OVEN TEMPERATURE:

Page 3

Required Date: 5/31/13 Reference: Approvals: QC: Sequence ID/ Work Center ID 150 *150* HandFinish Hand Finishing 155 *155* QC **Quality Control** 160 *160* Powdercoat Powder Coating m121279

Revision ID: Bracket Item Name: *10* 5/15/13 **Start Qty: 10.00** Start Date: Req'd Qty: 10.00 Process Plan: Date: Tooling: SPC (Y/N): Date: Operation Set Up/ Description Run Hours 0.00 Chemical Conversion Coat per QSI005 4.1 0.00 Memo OC7-Inspect Chemical Conversion Coat 0.00 0.00 Memo Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00

Memo

500F

START TIME:

FINISH TIME:

N900040100 Setup Start Cust Item ID: Customer: Run Date: Date: Reject Tool ID Tool# Plan Accept Reject Insp. Qty Qty Number Stamp Code 14 1613.95 14x pm/13/04/05 14xxm/13/54/05

		DQA:	Date:	
R: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

NCR:	Yes / No	WORK ORDER NON-CONFORMANCE /

											QA Closed:	Date	:
Work Orde	مخرد					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part No.				Rework Scrap Use-as-is		Machining Small Fab		Crosstube Small Fab Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other		
NCR N	10					Work Order Update			Large Fab	Composite	<u></u>	Supplier	
Root			Ò		Descri	ption of work order update	1	nitial	Ac	tion	Sign &		
Cause	1	Date	Step	Qty	+	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data							Γ		-				
Equip/Tooling													
Operator								:					
Material													
Setup													
Other													
Process								į					
Supplier													
Training													
Unapproved													
						F.	AUL	T CATE	GORY				
Landi	ng Gea	ar				General					_	_	_
	Ве	ending				Bend		Grain			Ovalized	L	Pressure/Forced
	Ce	entre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cr	acks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorred	ct	Weld
	Cr	ushed/0	Crimped			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cı	ıffs				Contamination		Mainte	nance		Part Moved		•
	Пн	eat Trea	t			Countersink		Mislabe	eled		Positioned V	Vrong	_
	☐in	spection	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other
	Ri	pples in	Bend			Drill Holes		Offset				<u>. </u>	
	□то	orque W	aves in E	xtrusio	n 🗌	Drawing		Out of 0	Calibration				
	<u></u> ті	arning Se	equence			Finish		Out of 9	Sequence				
	Πw	/ave/Tw	ist in Tul	oe .	Γ	Folio		Outside	Dimensions				

May-13-13 1:11:00 PM

Revision ID: Item Name:	D3207-5 Bracket 5/15/13 5/31/13	Start Qty: 10.00 Req'd Qty: 10.00	*10*	Accept	*N900 Cust Item Customer:	1D:	100)*	Setup Sta	1.71	S1* S2*
Reference: Approvals:	Process Pl		*10* Date:	Tooling:		ate:	- 		Run Sta	1/1	R1*
Sequence ID/ Work Center II 170 *170* QC Quality Control	QC:	Operation Description QC3- Inspect Part Finish Memo	Date:	SPC (Y/N): Set Up/ Run Hours 0.00 0.00	D	Pate: Tool #	Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*180 *180* Packaging Packaging		ldentify as per dwg & Sto	ock Location: <u>STJ</u> OJ	0.00				14 x	45	13-9-	6.
190 *190* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00					13	3/9/6	7 8

		DQA:	Date:	
NCP: Vec / No	WORK ORDER NON-CONFORMANCE / LIPDATE			

NCK: res / No WORK ORDER NON-CONFORMANCE / QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Engineering Skid-tube Water Jet Crosstube Rework Small Fab Prod. Eng. Coor. Quality Machining Part No. Scrap Thermoforming Finishing Rec/Store/Packaging Other Use-as-is NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Sign & Initial Action Root or Non-conformance Chief Eng Description Date Verification QC Inspector Date Step Qty Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Ovalized Pressure/Forced Bending Bend Grain Temperature/Cure Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Broken/Damaged Inspection Incomplete Weld Cracks Part Incorrect Wrong Stock Pulled Crushed/Crimped Part Lost/Missing Burrs Instructions Incomplete/Unclear Cuffs Maintenance Part Moved Contamination Countersink Mislabeled Positioned Wrong Heat Treat Other Misread Inspection Strip in Tube Cut Too Short Power Loss/Surge **Drill Holes** Offset Ripples in Bend Torque Waves in Extrusion Out of Calibration Drawing Finish Out of Sequence Turning Sequence

Outside Dimensions

Wave/Twist in Tube

Folio

Picklist Print

May-13-13 1:10:59 PM

Work Order ID:

101658

Parent Item:

D3207-5

Parent Item Name:

Bracket

Start Date: 5/15/13

Required Date: 5/31/13

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP A04.06.09New issueKJ/RF

IPP REV C AS PER REV B 12-03-23 JLM

VERHFIED BY:EC IPP REV:D 12.05.10 per dwg rev.c DD verf:EC

Replacement Qty per Kit Total Last Unit of Qty on Date Status Component Item ID/ Mfg/ Qty Bin Primary Route Measure Hand Issued Item Name Item ID Location Location Seq ID Qty Issued Item Purch No 100 sf 187.9862 0.0736 M6061T6S.125 Purchased -0.774737 6061-T6 .125 Sheet Location Loc Qty Loc Code

 Location
 Loc Qty
 Loc

 MAT021
 187.9861578
 121473

 123279
 72.89

 125257
 114.18

125257

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									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	CONFO	RMANCE / UF	PDATE	QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is	The	Skid-tube Machining rmoforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No.					Work Order Update		Large Fab	Composite	nec/sto	Supplier	
Root				Descr	iption of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling										İ	
Operator											
Material											
Setup]					1]		
Other	1		1							<u> </u>	

•		.	FAUL	T CATEGORY		
Landing	Gear	General			 	
Γ	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset	 	•
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio		Outside Dimensions		

Process Supplier Training Unapproved

DART AEROSPACE LTD	Work Order:	101658
Description: Bracket	Part Number:	D3207-5
Inspection Dwg: D3207 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.93	+/-0.010	2,92	-	<u> </u>	٧	UKM-01
2.376	+/-0.010	2.376			√	•
3.200	+/-0.010	3.200	_		٧	
R0.25	+/-0.030	. 25	_		1 RG	
R0.50	+/-0.030	.50	_		\$ 12G	
R0.75	+/-0.030	,75	_		VRG	<u> </u>
Ø0.438	+0.005/-0.000	.437				
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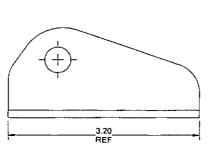
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			04.0			

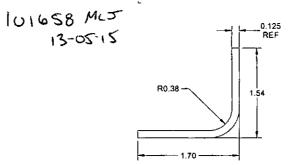
Measured by: Ae	Audited by:	Preliminary Approval:
Date: 13.08-13	Date: 13-8-15	Date:

Rev	Date	Change	Revised by	Approved
Α	05.02.17	New Issue	KJ/JLM 1	2/8
В	12.06.21	Dimensions updated per Dwg Rev C	KJ CAN	1/11

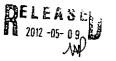
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D3207-5 BRACKET



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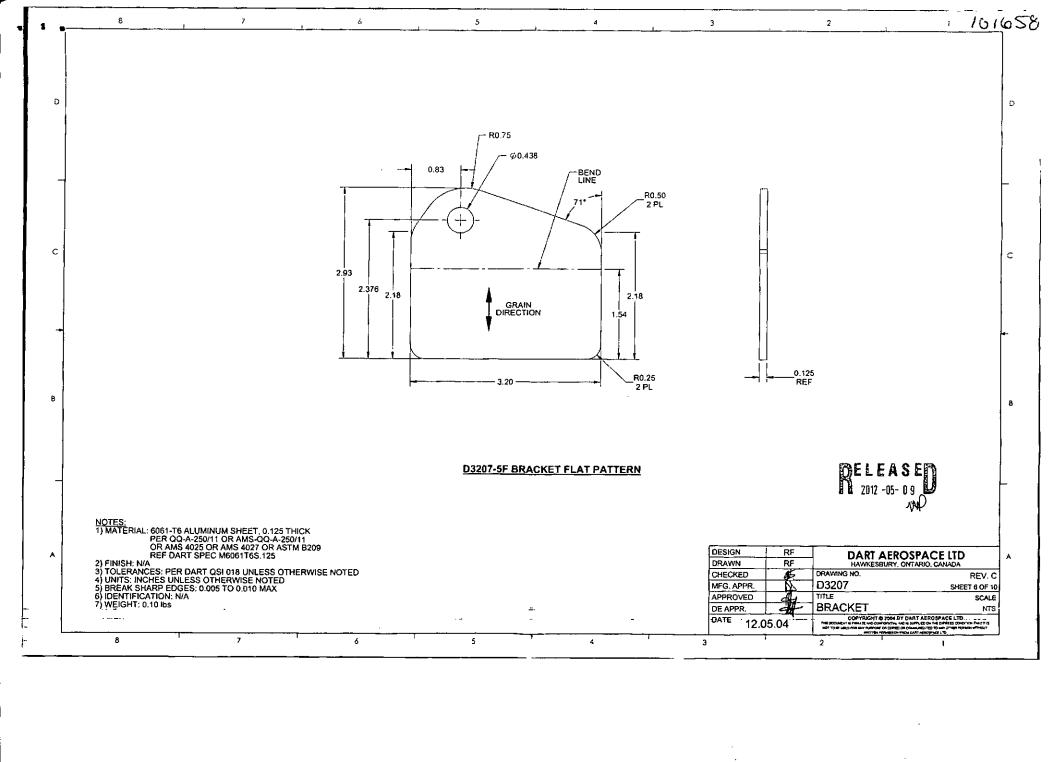
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NOTES:
1) MATÉRIAL: MAKE FROM D3207-5F FLAT PATTERN
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.10 lbs

8

DESIGN	RF	DART AEROSPACE LTD		
DRAWN RF		HAWKESBURY, ONTARIO, CANADA		
CHECKED	5 5	DRAWING NO.	REV. C	
MFG. APPR.	7	D3207	SHEET 5 OF 10	
APPROVED	Ah.	TIFLE	SÇALE	
DE APPR	~ <i>!!!</i>	BRACKET	NTS	
DATE 12.05.04		COPYEIGHT Q 2004 BY QART ACROSPACE LTD MIS DOLLARY IS SENTLY BOY DESTRUCTION AND BY GARDS ON THE STREET SCOTTON THAT IT IS MIST TO BE LUXUD FOR ANY PLEYDOID OF DOMES ON COUNTY TO TO SENT COUNTY OF THE STREET SENT COUNTY OF THE SENT COUNTY OF THE SENT COUNTY OF THE SENT COUNTY		

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